

Date: Wednesday, 14/11/2007 10:34:07 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
 Job Number : 35718
 Estimate Number : 10258
 P.O. Number : *N/A*
 This Issue : 14/11/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : SMALL / MED FAB
 Previous Run : 33467
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/
 RF

Part Number : D2332041
 Drawing Number : D2332 REV C1
 Project Number : N/A
 Drawing Revision : C1
 Material : *N/A*
 Due Date : 23/11/2007 Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR1000W049 304 RD Tube 1.0" x .049W



Comment: Qty.: 0.4331 f(s)/Unit Total: 12.9938 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch

M105260 27 (M103240 3X)

2.0 M304R250 1/4" 304 SS Roundbar



Comment: Qty.: 0.1092 f(s)/Unit Total: 3.2760 f(s)

Material: Ø0.250" 304SS Rod

Batch *M105950*

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

4.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 1.2502 f(s)/Unit Total: 37.5060 f(s)

304 RD Tube .500 x .035W

M 106 015

M 105 575

85 07/11/14

M 105 354

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

SB 07/11/14 (30)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

A/R SS Rod Batch: M105138

FC 07/12/04 (30)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-12-06 (30)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CC 07/12/07 (30)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

SB 07/12/12 (30)

SB

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number Description
1 AN4-4A Bolt

Batch

M101291

SB 07/12/12 (30)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/12/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 90.0000 Each(s)

Pick:

Qty Part Number Description
3 AN960JD416L Washer

Batch

M105 728

07/12/12 (30)

12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part Number Description
1 MS21042L4 Nut (or -4)

Batch

M105054

07/12/12 (30)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/12/13 (30)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST203

W

02/12/13

(30)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

02/12/14

Job Completion

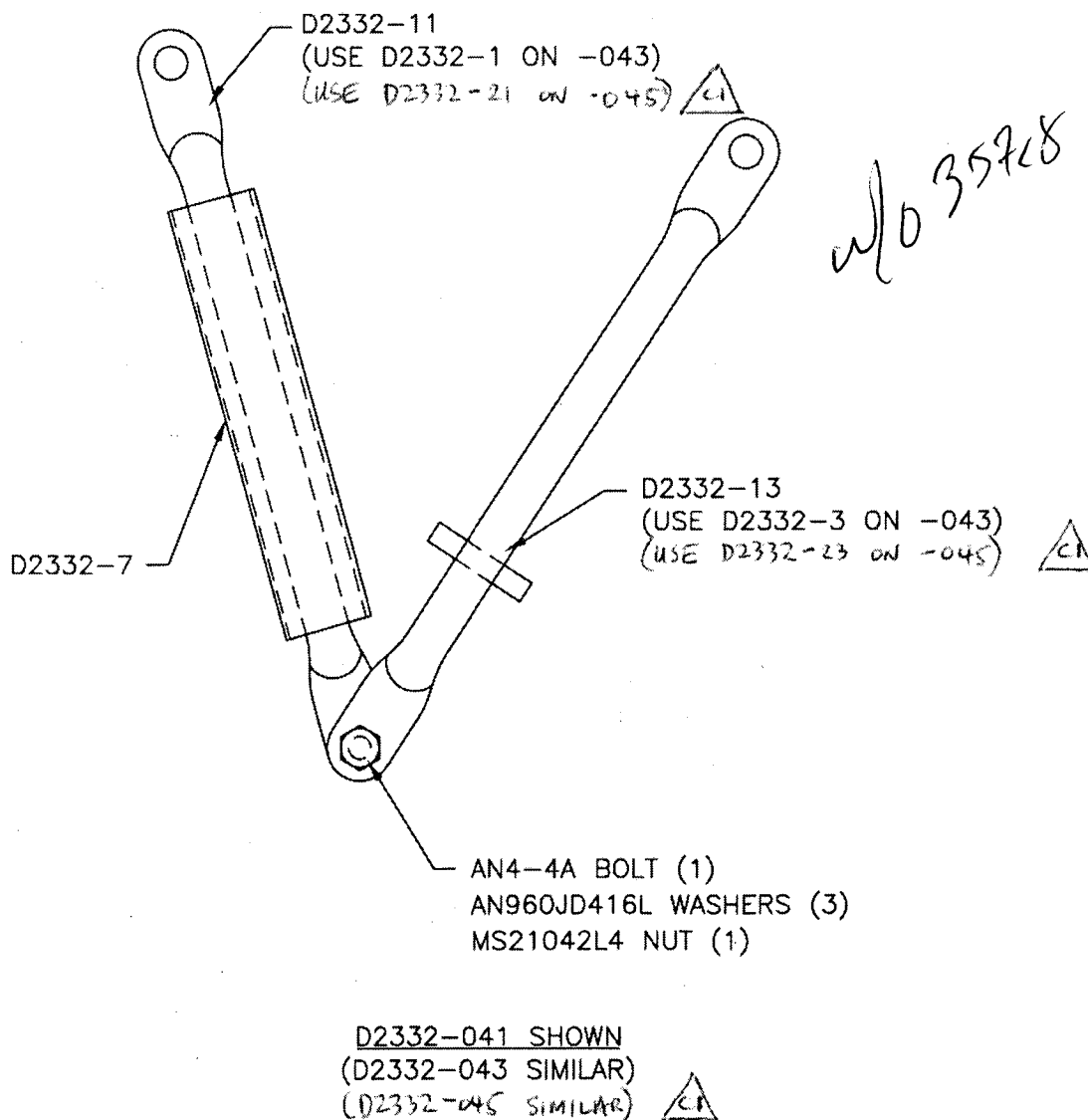


W 07.12.14



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03	TITLE LOD PROP ASSEMBLY		SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.35" LONG)	

RELEASED
03.07.04



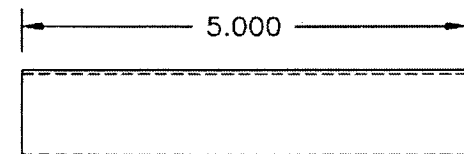
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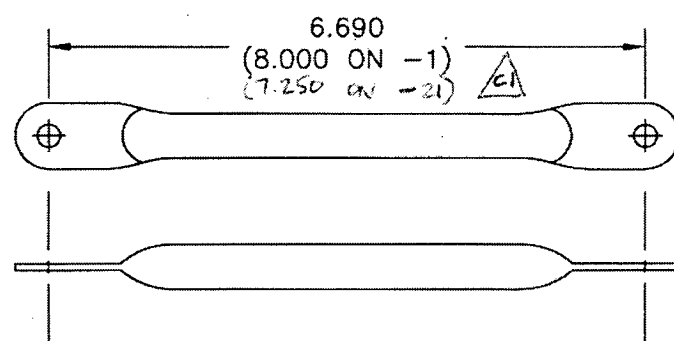
DART

QA COPY ISSUED

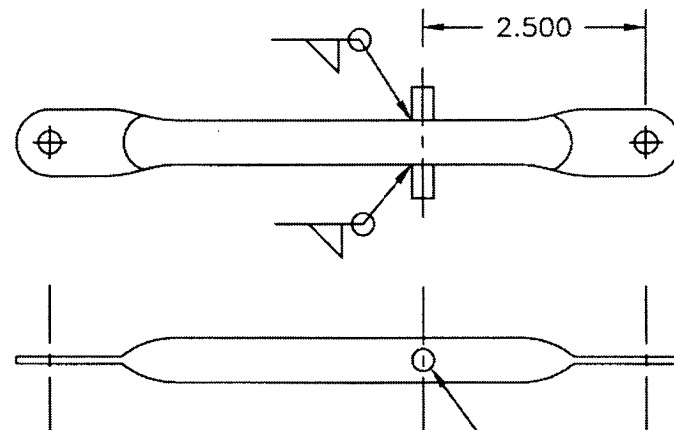
DESIGN	DRAWN BY	DART AEROSPACE LTD
#	#	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2332
DATE	TITLE	REV. C
03.07.03	LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2



D2332-7 LOCKING COLLAR



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

{D2332-3 SIMILAR - M/F D2332-1 & D2332-5}
{D2332-23 SIMILAR - M/F D2332-21 & D2332-5}

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

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